

Date: Wednesday, 1/31/2007 2:18:17 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARPAW KIT (EC 135)
Job Number : 30542	
Estimate Number : 10536	
P.O. Number : <i>N/A</i>	Part Number : D135692011
This Issue : 1/31/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3049 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : A1
Previous Run : 28381	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 2/12/2007
Checked & Approved By : <i>[Signature]</i> 07.02.01	Qty: <i>3</i> Um: Each
Comment : Est Rev: C 04.02.17 Blank size changed, Tolerance added Step 3 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D135-692-011 CHG002

07.02.05 KJ

2.0

MUHMWB10

UHMW 1" Black



Comment: Qty.: 5 sf(s)/Unit Total : 27 sf(s)

blank: 16.00" x 23.50" x 1.00" thick (+0.030/-0.000)

per DSK086-9

Material: Black UHMW 1"(MUHMWB10)

Batch: *M1021641**Not enough Material SD 07.02.24*

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note: (2) Bearpaw for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio FA165 and Dwg D3049 Identify as D3049-1

3-Deburr

SD 07.02.24

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD 07.02.24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:18:17 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (EC 135)

Job Number: 30542

Part Number: D135692011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

En 07/02/26 3 Kits

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Neoprene Cushion-.750 bl



Comment: Qty.: 1 f(s)/Unit Total: 3 f(s)

Pick: Packing Kit

Qty Part Number Description Batch
4 D2182B060 Rubber Cushion B30397 ✓

8.0

D2274

Radius Block



Comment: Qty.: 8 Each(s)/Unit Total: 40 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
8 D2274 Radius Block B30380 ✓

9.0

D2519

Clamp



Comment: Qty.: 4 Each(s)/Unit Total: 20 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
4 D2519 Clamp M18892 (10x) 26216 (2x) ✓

10.0

D2529

Washer



Comment: Qty.: 8 Each(s)/Unit Total: 40 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
8 D2529 Washer B28733 ✓

11.0

AN415A

Bolt



Comment: Qty.: 8 Each(s)/Unit Total: 40 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
8 AN4-15A Bolt M103585 ✓

07/02/2008

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 18 Date: 07/02/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/31/2007 2:18:17 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW KIT (EC 135)

Job Number: 30542

Part Number: D135692011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN960JD416

Washer



Comment: Qty.: 8 Each(s)/Unit Total : 40 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN960JD416 Washer M103338 ✓

13.0

MS21042L4

Nut



Comment: Qty.: 8 Each(s)/Unit Total : 40 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4 Nut (or -4) M103349 ✓

14.0

QS100M24S

Clamp



Comment: Qty.: 4 Each(s)/Unit Total : 20 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3049-1(ref) Bearpaw

4 QS100M24S Clamp

1 Paperwork package from Step 2(ref)

M102023 (7X) M100622 (2X) M103481 (3X) 07/02/26 (3)

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D135-692-011

Location: _____

PPP Rev: _____

07/02/27 (3)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/27 (3)

Job Completion



07/02/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 30542
Description: Bearpaw		Part Number: D3049-1
Inspection Dwg: D3049	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø0.260	+0.005/-0.000	Ø.260	/			
B	0.93	+/-0.030	.930	/			
C	0.40	+0.030/-0.000	.400	/			
D	2.00	+/-0.030	2.000	/			
E	10.250	+/-0.010	10.250	/			
F	4.540	+/-0.030	4.540	/			
G	5.88	+/-0.030	5.875	/			
H	0.38	+/-0.030	.380	/			
I	15.50	+/-0.030	15.50	/			
J	0.07 x 45°	+0.030/-0.010	.065 x 45°	/			
K	0.44 - 0.47	+/-0.000	.470	/			
L	R0.25	+/-0.030	R.25	/			
M	0.38	+/-0.010	.388	/			
N	0.95	+0.030/-0.010	.973	/			
O	0.69	+/-0.030	.720	/			
P	0.20	+/-0.030	.210	/			
Q	23.00	+/-0.030	23.00	/			
R	0.25 x 45°	+/-0.030	.25 x 45°	/			

Measured by: SN	Audited by: 36	Prototype Approval: N/A
Date: 01.02.25	Date: 01.02.25	Date: N/A

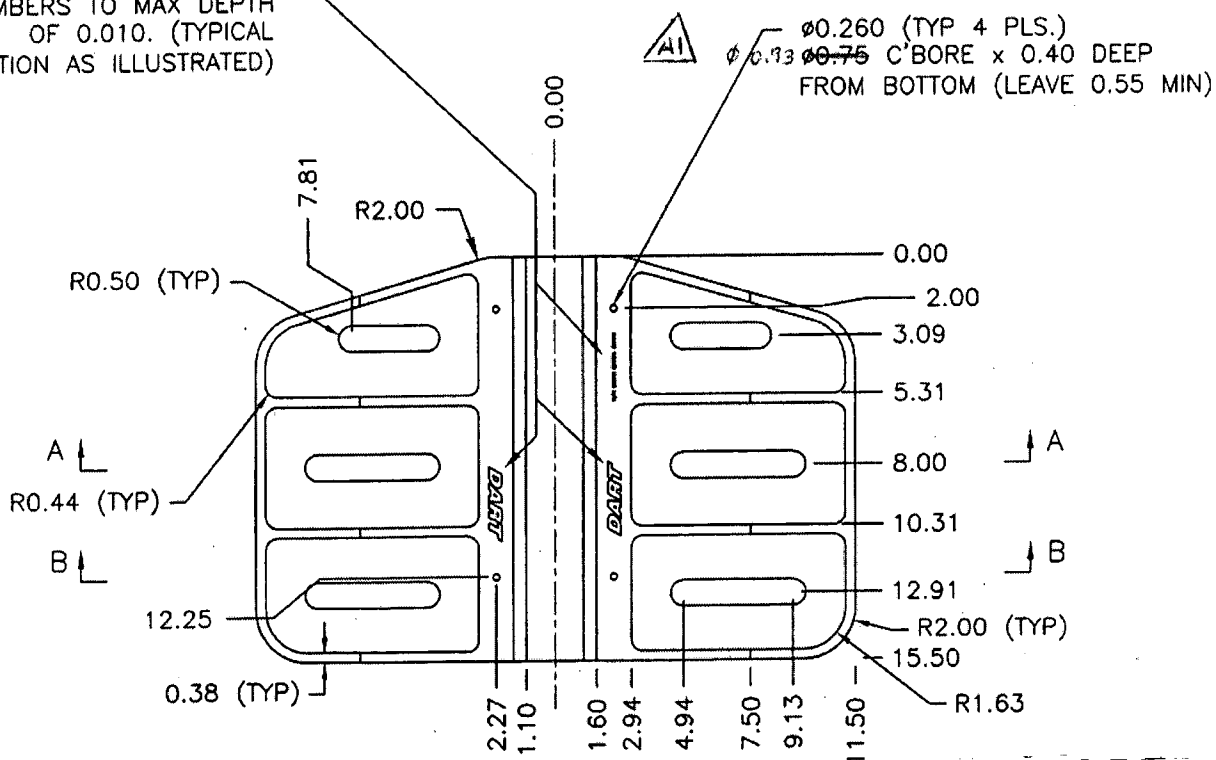
Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D135-692-011	KJ/RF	



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3049	REV. A SHEET 1 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:7
A	01.10.18	NEW ISSUE	
AI	[Signature] RF 03.01.13	$\phi 0.93$ W $95 \phi 0.75$	

RELEASED
01.10.24 [Signature]

ENGRAVE DART LOGO TO
MAX DEPTH OF 0.012.
ENGRAVE PART AND BATCH
NUMBERS TO MAX DEPTH
OF 0.010. (TYPICAL
LOCATION AS ILLUSTRATED)



D3049-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)

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WITHOUT NOTICE
WORK ORDER
NO. 30542

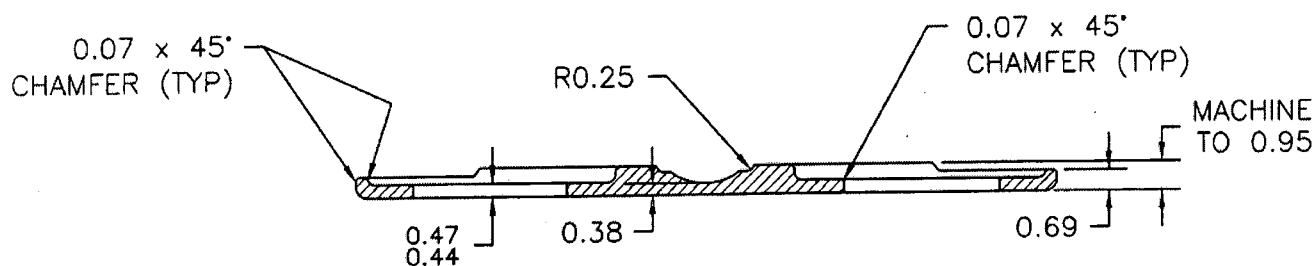
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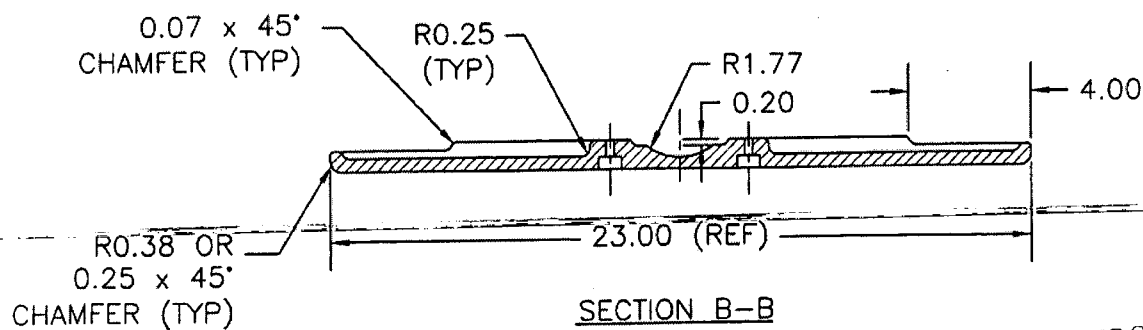


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3049	REV. A SHEET 2 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:6

RELEASED
01.10.24 #



SECTION A-A



SECTION B-B

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